

COMPONENT APPLICATION SHEET

DOMINATOR - 7 - 0602



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|----------------------|---|
| MACHINE | Dominator 634 - Production CNC Surface/Creepfeed Grinder |
| COMPONENT | High Pressure (HPT) Turbine Blade |
| TOLERANCE | 0,010mm (0.0004") on size |
| STOCK REMOVAL | 4,5mm (1.177") |
| DRESSING | Formed diamond table roll dresser |
| MATERIAL | Inconel |
| COOLANT | High pressure, high volume to aid the grinding process |
| OPERATION | Grind rootform each side in two operations, with table reciprocation set at 200 strokes per minute |

COMPONENT APPLICATION SHEET

ULTRAMAT - 18 - 1102



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| MACHINE | Ultramat CNC - Plain Wheelhead Production Cylindrical Grinder |
| COMPONENT | Spherical Bearing (External & Internal) |
| TOLERANCE | $\pm 0,005\text{mm}$ ($\pm 0.0002''$) Diameter & Spherical / Roundness Geometry |
| SIZE | 44mm (1.732'') |
| MATERIAL | High Carbon Steel |
| OPERATION | Grind Sphere with ISO Formed External Grinding Wheel |
| STOCK REMOVAL | 0.25mm (0.01'') |

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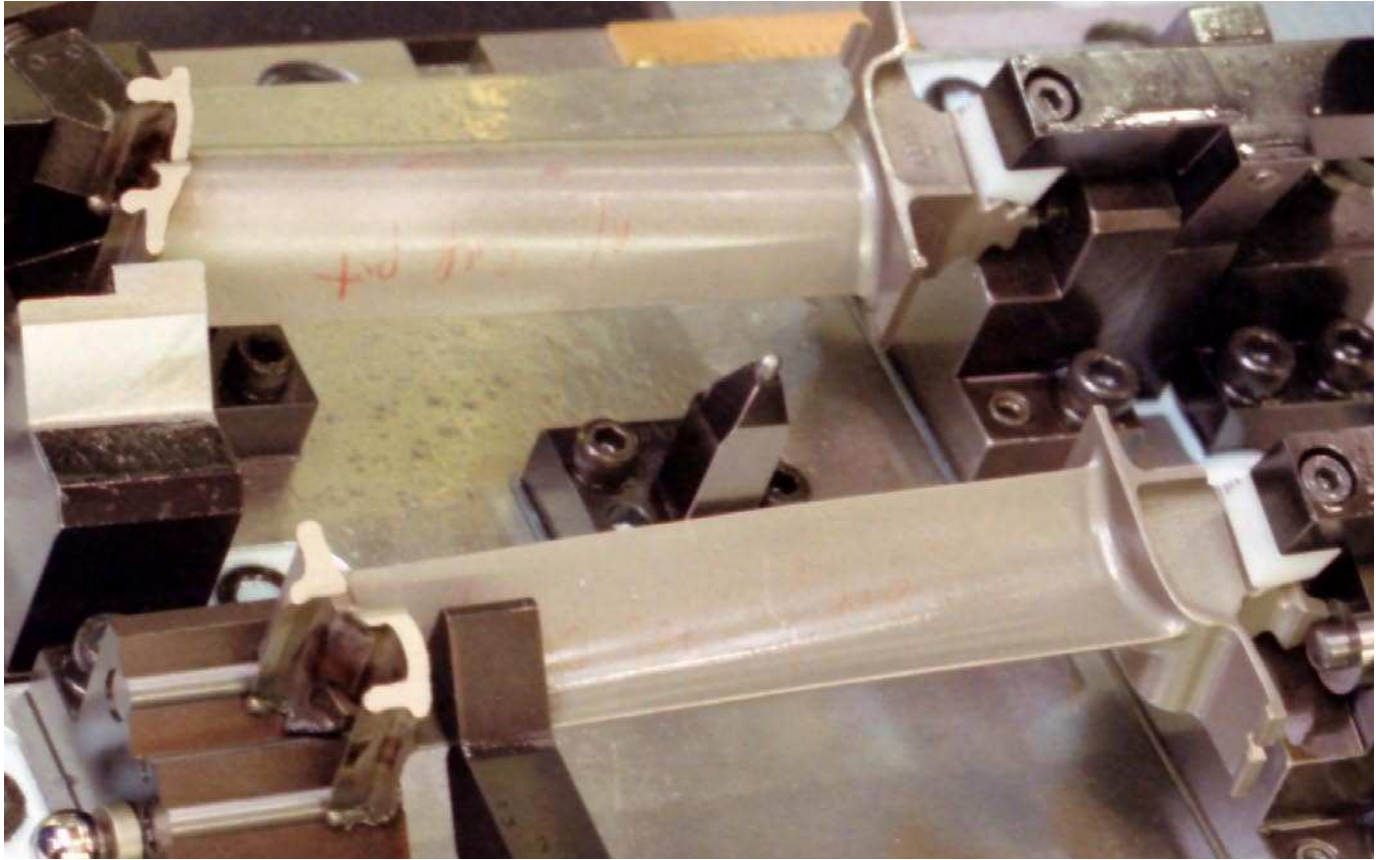
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COMPONENT APPLICATION SHEET

DOMINATOR - 22 - 0802



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|----------------------|---|
| MACHINE | Dominator 634CD/RT - Production CNC Surface/Creepfeed Grinder |
| COMPONENT | Turbine Blade (Reconditioning) |
| TOLERANCE | 0,025mm (0.001") |
| SIZE | 160mm (6.30") Long Ground area 30 x 15mm (1.18" x 0.59") |
| MATERIAL | Welded Inconel |
| OPERATION | Grind 'Z' notch 'Interlock' using twin spaced wheels, dressed from overhead diamond roll |
| STOCK REMOVAL | 3mm (0.12") off Weld |

COMPONENT APPLICATION SHEET

ULTRAMAT - 10 - 0602



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|----------------------|---|
| MACHINE | Ultramat CNC - Plain Wheelhead Production Cylindrical Grinder |
| COMPONENT | Aerospace Actuator |
| SIZE | Ø 30 x 85mm (1.181" x 3.346") |
| TOLERANCE | ± 0,01mm (± 0.0004") |
| MATERIAL | S132 |
| OPERATION | Dress double sided facing wheel using standard dress cycle Grind 2 - 12mm (0.472") Bearing diameters and 2 Faces |
| STOCK REMOVAL | 0,2mm (0.008") |

COMPONENT APPLICATION SHEET

ULTRAMAT - 12 - 0602



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| MACHINE | Ultramat CNC - Universal Wheelhead Production Cylindrical Grinder |
| COMPONENT | Aerospace Seal Adaptor |
| SIZE | Ø 72 x 125mm (Ø 2.834" x 4.921") |
| TOLERANCE | Concentricity 0,005mm (0.00019") TIR |
| MATERIAL | Unspecified |
| OPERATION | <p>Dress double sided facing wheel using standard dress cycle</p> <p>Plunge & face grind front Ø 56mm (Ø 2.204")</p> <p>Plunge & face grind second Ø 56mm (Ø 2.204")</p> <p>Shoulder grind front face of component</p> <p>Plunge & face grind Ø 54mm (Ø 2.125")</p> <p>Step over 2 plunges & traverse grind to finish Ø 54mm (Ø 2.125")</p> <p>Plunge grind with oscillation Ø 72 x 6mm (Ø 2.834" x 0.236")</p> <p>Radius & diameter dress internal wheel.</p> <p>Internal Grind Ø 50mm (Ø 1.968") bore & internal radius</p> <p>Traverse grind Ø 40 x 10mm (Ø 1.574" x 0.393") bore</p> |

COMPONENT APPLICATION SHEET

ULTRAMAT - 9 - 0602



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|----------------------|--|
| MACHINE | Ultramat CNC - Plain Wheelhead Production Cylindrical Grinder |
| COMPONENT | Aerospace Valve Body |
| SIZE | Ø 20 x 67mm (0.787" x 2.638") |
| TOLERANCE | ± 0,015mm (± 0.0006") |
| MATERIAL | S99 |
| OPERATION | Dress ISO profile Grind all diameters and radii |
| STOCK REMOVAL | 0,2mm (0.008") |

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COMPONENT APPLICATION SHEET

ULTRAMAT - 11 - 0602



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|----------------------|---|
| MACHINE | Ultramat CNC - Plain Wheelhead Production Cylindrical Grinder |
| COMPONENT | Aerospace Valve Sleeve |
| SIZE | Ø 40 x 150mm (Ø 1.574" x 5.90") |
| TOLERANCE | ± 0,015mm (± 0.0006") |
| MATERIAL | S99 |
| OPERATION | Dress single sided facing wheel using standard dress cycle. Plunge & shoulder grind. Step over 2 plunges and Traverse grind to finish. |
| STOCK REMOVAL | 0,2mm (0.008") on Diameter 0,1mm (0.004") on Face |

COMPONENT APPLICATION SHEET

ULTRAMAT - 5 - 0602



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|------------------|---|
| MACHINE | Ultramat CNC - Plain Wheelhead Production Cylindrical Grinder |
| COMPONENT | Flap Actuator |
| SIZE | 72mm x 125mm (2.834" x 4.921") |
| TOLERANCE | 0,005mm (0.00019") |
| MATERIAL | High Chrome Steel |
| OPERATION | Dress double sided facing wheel using standard dress cycle Plunge grind 8 diameters and 4 shoulders for Concentricity and Squareness |

COMPONENT APPLICATION SHEET

ULTRAMAT - 8 - 0602



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|----------------------|--|
| MACHINE | Ultramat CNC - Plain Wheelhead Production Cylindrical Grinder |
| COMPONENT | Fuel Flow Valve |
| SIZE | Ø 10mm x 60mm (Ø 0.393" x 2.362") long |
| TOLERANCE | 0,005mm (0.00019") |
| MATERIAL | Stainless Steel |
| OPERATION | Dress single sided facing wheel using standard dress cycle Plunge grind 2 - 8mm (0.314") diameters, Angle Shoulder grind 1 Seal Face. |
| STOCK REMOVAL | 0,5mm (0.019") on Diameter 0,3mm (0.118") on Face |

COMPONENT APPLICATION SHEET

ULTRAMAT - 13 - 0602



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|------------------|--|
| MACHINE | Ultramat Easy - Plain Wheelhead 'Teach' Cylindrical Grinder |
| COMPONENT | Spool Valve |
| SIZE | Ø 8 x 150mm (Ø 0.314" x 5.905") |
| TOLERANCE | ± 0,010mm (± 0.00039") |
| MATERIAL | D2 |
| OPERATION | Dress grinding wheel Traverse grind |